

ASAP

Tuesday, 3/18/2008 3:55:28 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 38091	
Estimate Number : 10606	
P.O. Number :	Part Number : D33193
This Issue : 3/18/2008 S.O. No. :	Drawing Number : D3319 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 36045	Material :
Written By :	Due Date : 4/10/2008 Qty: 10 Um: Each
Checked & Approved By : <u>ASAP 03 18</u>	
Comment : Est: A 05.05.12 New issue KJ/JLM	
Est Rev:B Now on Waterjet 06-10-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048



Comment: Qty.: 3.4150 sf(s)/Unit Total : 34.1502 sf(s)
1010/1025/A21/6aA SHEET .048" Thick
Batch: 106603 IB 8-3-19

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3319
Dwg Rev: B
Prog Rev: B

IB 8-3-19

(10)

2-Deburr if necessary IB 8-3-19

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



IB 8-3-19

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/03/20

(10)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:55:29 PM
User: Kim Johnston

Process Sheet

30/08/08
S.051 15230
#1 322.5
#2 38071
#3 0.33193
#4

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38091

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 08/03/20 (10)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 08/03/20 (10)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty: Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

H106392

08-04-15 (10x)

9.0

QC 10 & 5

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-04-15 / S 08/04/15 (10)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 106442 (10)
BL 08-04-17

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FD 08/04/18 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: _____

LC 8/4/18 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/18/2008 3:55:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 38091

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/18 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-04-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	38091
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

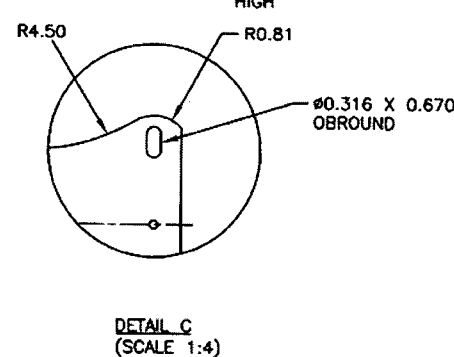
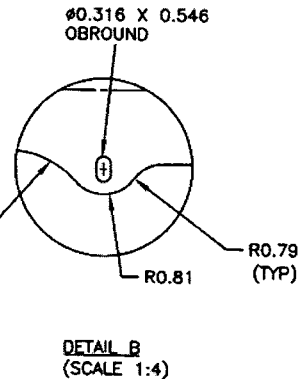
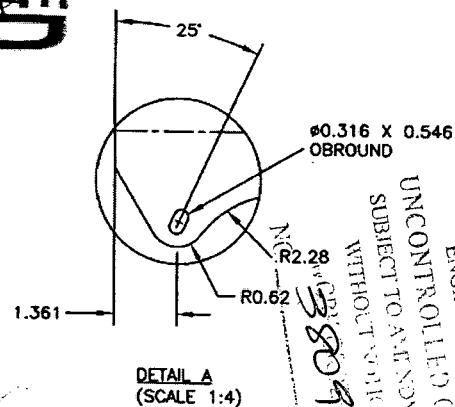
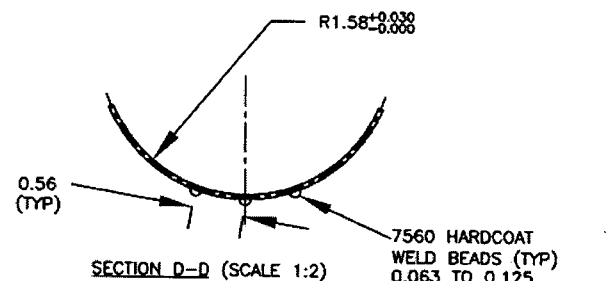
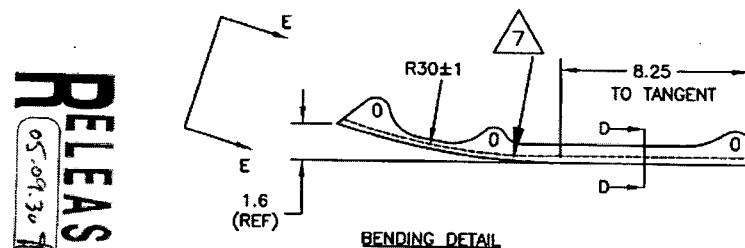
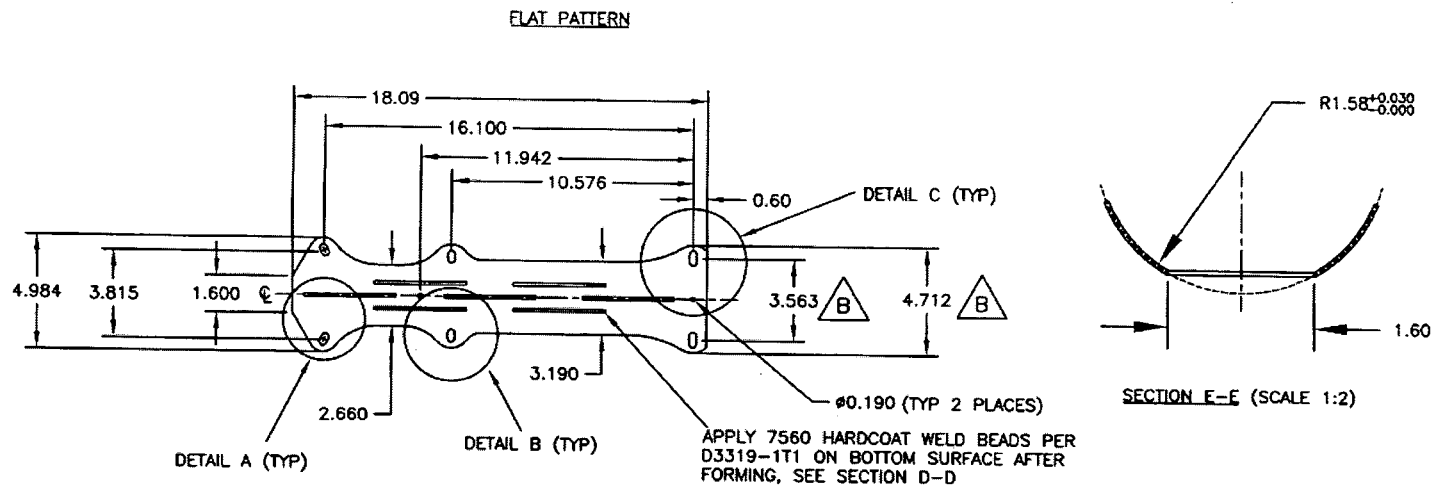
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	*			
74.420	+/-0.010	74.420	*			
62.770	+/-0.010	62.770	*			
52.890	+/-0.010	52.890	*			
30.790	+/-0.010	30.790	✓			
8.690	+/-0.010	8.690	✗			
0.60	+/-0.030	.60	*			
2.690	+/-0.010	2.697	*			
2.940	+/-0.010	2.942	*			
3.527	+/-0.010	3.526	*			
4.518	+/-0.010	4.519	*			
Ø0.190	+0.005/-0.001	.194	*			
2.940	+/-0.010	2.946	*			
2.940	+/-0.010	2.946	*			
2.690	+/-0.010	2.694	*			
5.063	+/-0.010	5.062	*			
6.163	+/-0.010	6.162	*			
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	316X.608	*			
0.048	+/-0.010	.047	*			

Measured by: LB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-3-19	Date: 08/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM [Signature]	[Signature]

DART



D3319-1 WEARPLATE

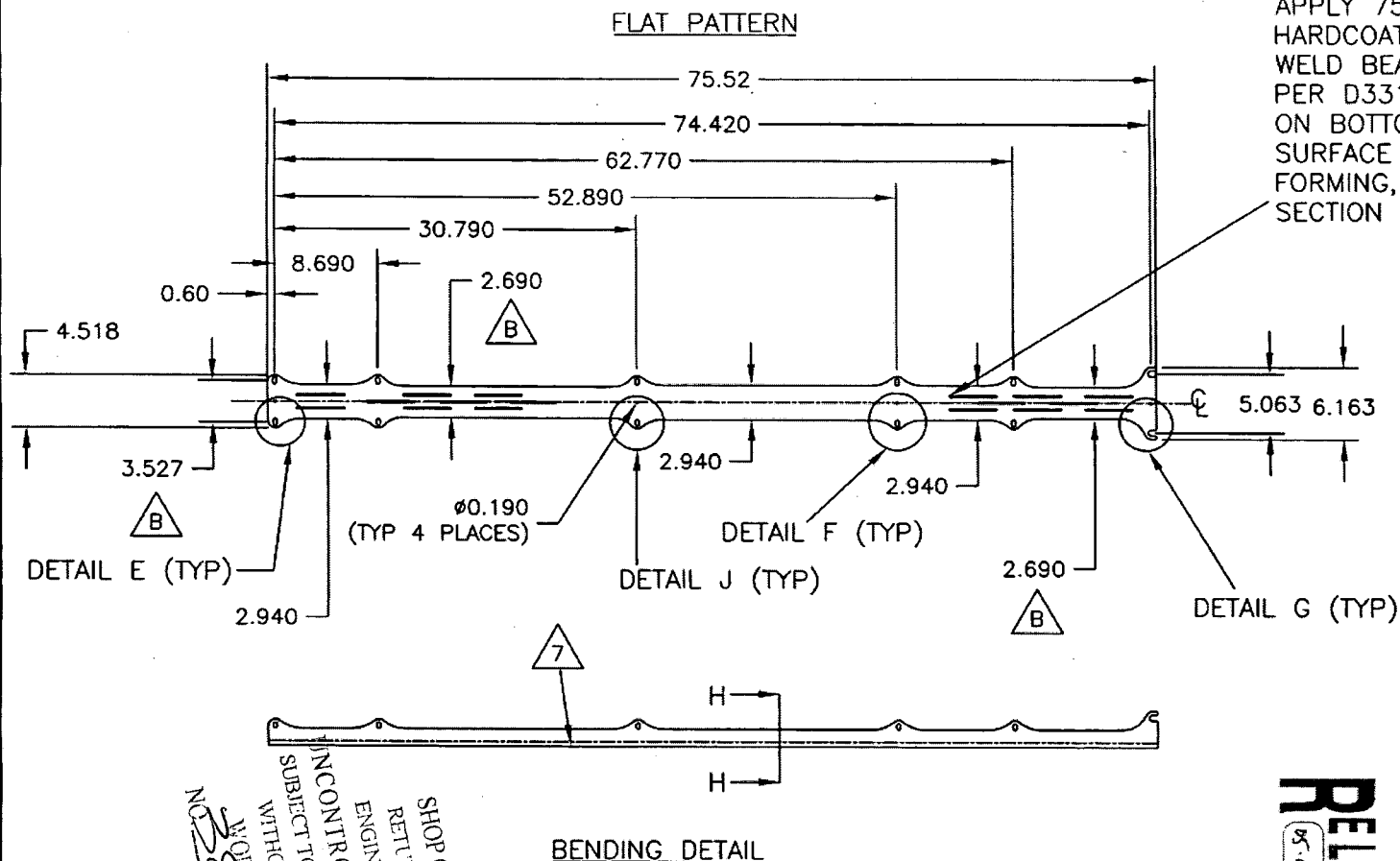
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
P11	04	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D3319
DATE	TITLE	REV. B
05.06.06	WEARPLATE	SHEET 1 OF 5
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7
		SCALE 1:8

RELEASED
05-09-30

DESIGN	074	UNWIN B1	DARI AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA		REV. B
CHECKED	<i>[Signature]</i>	APPROVED	DRAWING NO. D3319	SHEET 2 OF 5	
DATE	05.06.06		TITLE	WEARPLATE	
				SCALE	1:15

05-09-30



D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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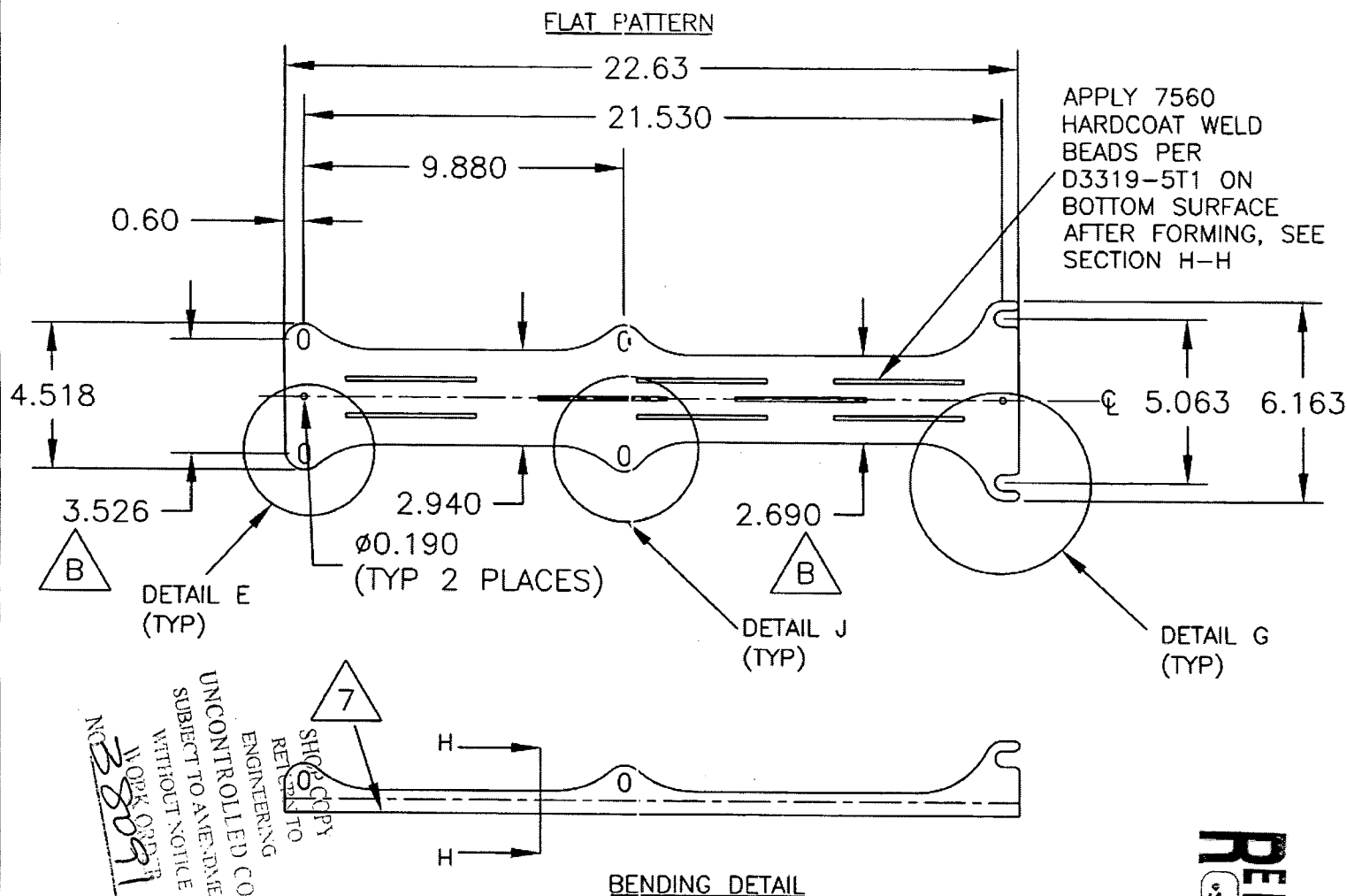
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DART

DESIGN	D41	DRAWN BY	D44	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 3 OF 5
				SCALE 1:5

RELEASED
05-07-30

APPLY 7560
HARDCOAT WELD
BEADS PER
D3319-5T1 ON
BOTTOM SURFACE
AFTER FORMING, SEE
SECTION H-H



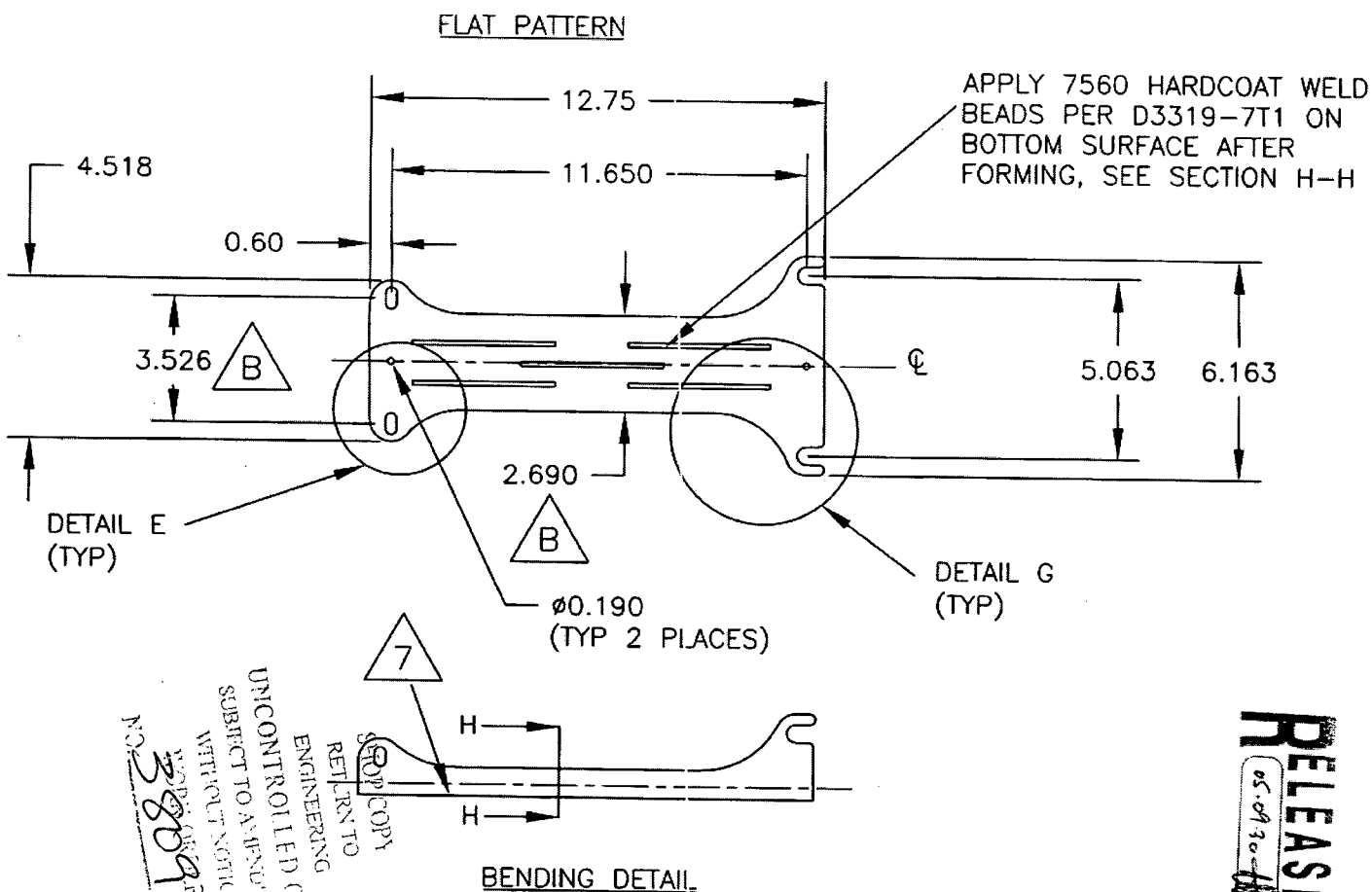
D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 4 OF 5
		SCALE	1:5	

RELEASED
05.09.30.11



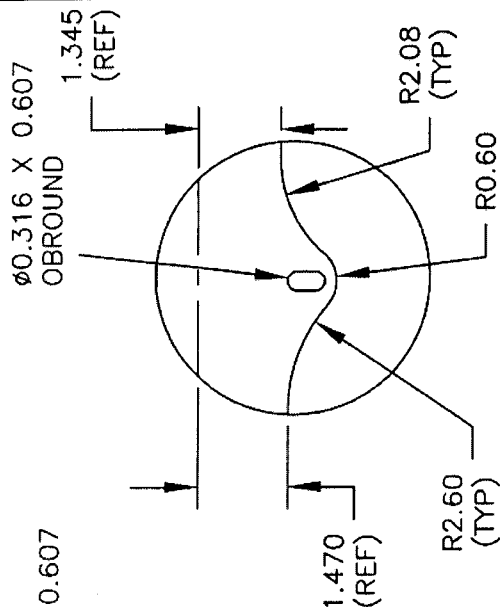
D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

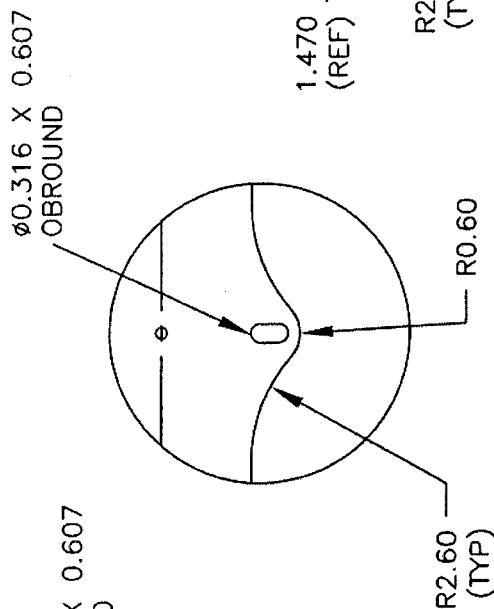


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06	TITLE WEARPLATE		SCALE 1:3

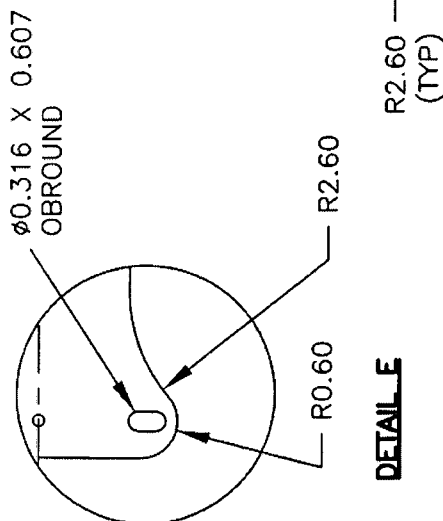
RELEASED
05-09-30



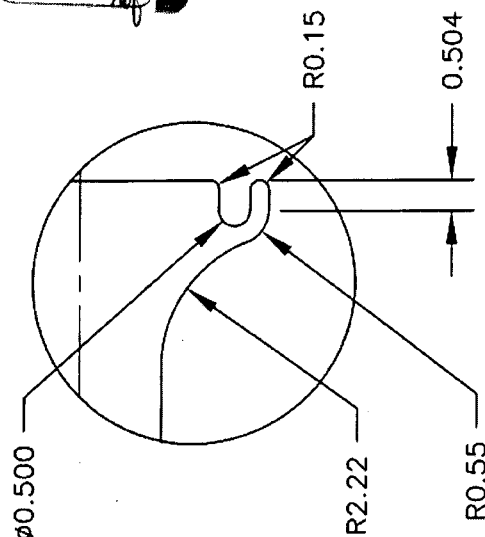
DETAIL J



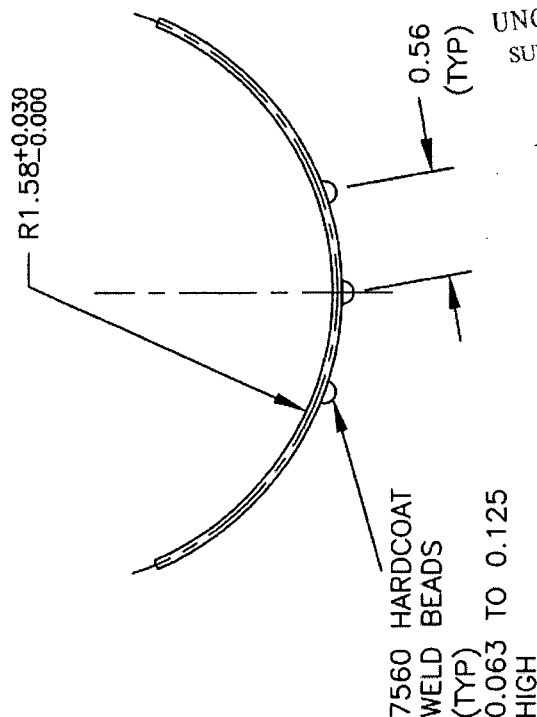
DETAIL I



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

SHOP COPY
RETURN TO
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